

Work Order ID 140770

140770

Page 1

Monday, January 18, 2016 10:04:45 AM

Item ID: D2594-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: O-Ring
 Start Date: 1/18/2016 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: MLS Date: JAN 18 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2594	Rev C

100 PURCHASING 0.00 **DAS 13 9-89** JAN 18 2016 200
 100 Purchasing Memo 0.00
 Purchasing Issue P/O: 31039 Purchase as per Dwg D2594 Possible P/N: Parker 2-011 Material release note is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110 Packaging Memo 0.07
 Packaging Ensure Material Release Note is attached 200 Sp/6-01-21

120 QC6- Inspect dimensions to drawing 0.00
 120 QC Memo 0.00
 Quality Control 200 **DAS 38 9-89** JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 140770

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Page 2

Monday, January 18, 2016 10:04:45 AM

Item ID: D2594-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: O-Ring
 Start Date: 1/18/2016 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Y</u>	0.00							
130									
Packaging	Memo	0.03							
Packaging	LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33							
Quality Control									

Signature 20160121

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Comments: IPP B04.06.08Reformat; Added Powder CoatKJ/JLM
IPP C 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS28775-011		Purchased	No			100	Each	0.0000	1	200			
MS28775-011									**	200x 8/16-4-21			
O-Ring													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

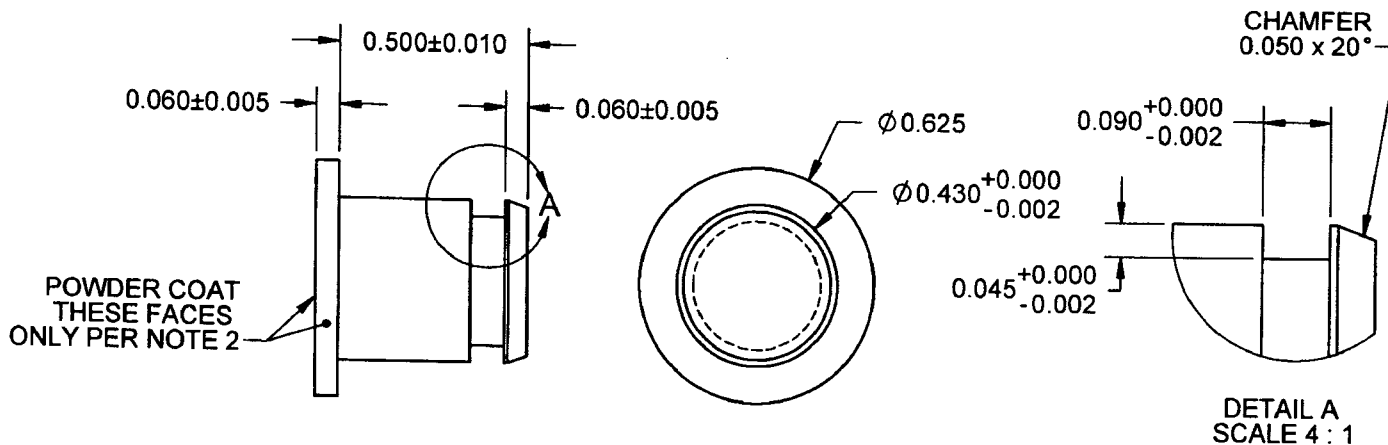
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

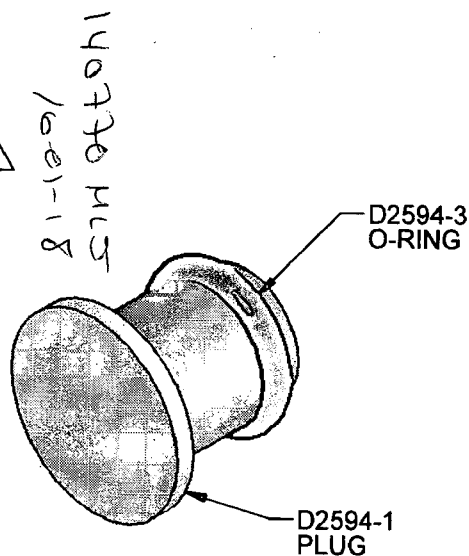
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31039

Purchase Order Date 1/18/2016

PO Print Date 1/19/2016

Page Number 5 of 7

Order From :

AVIALL
PO BOX 842275

DALLAS, TX 75284-2275
USA

VU-AVI003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

905-676-1695

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

EXW - (Ex Works)

14	NAS1149D0463J	WASHER	1/20/2016	FN	5,000.00	\$0.03	\$150.00
			Yes		Each		
			1/20/2016		4000		

260A

Line Total: \$150.00

16	71400-11	PRO-SEAL PS890-2B PINT SIZE	1/20/2016		8.00	\$64.70	\$517.60
			Yes		Each		
			1/20/2016				

EXP DATE: 10/01/2016 260 DAYS

Line Total: \$517.60

18	MS28775-011	O-Ring	1/20/2016		200.00	\$0.15	\$30.00
			Yes		Each		
			1/20/2016				

AS PER DWG D2594 REV. C
B140770

Line Total: \$30.00

Sp/6-01-21

PO Instructions: Fedex Acc#151793240

Note:

1/19/2016

ODO: 310003664206

ROUTE: FDXIPA

TIME: 20:12:02



Handling Unit: 110000000489353594

Packed at WorkCenter: SI09

CUSTOMER PO:PO31039
ORDER NUMBER:8002678875

B CU10003951
I DART AEROSPACE LTD
L 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
T CANADA
O

S CU10003951
H DART AEROSPACE LTD
I 1270 ABERDEEN STREET
P HAWKESBURY ON K6A 1K7
T CANADA
O

S 1000
H AVIALL CENTRAL WAREHOUSE
I DALLAS CDC
P PO Box 619048
F DFW AIRPORT TX 75261-9048
R USA
O

LINE	PO LINE	MFG	ITEM DESCRIPTION	ORDER QUANTITY	SHIP QUANTITY	UOM
00110		28	MS27039-5-08=28 SCREW: PAN HD,ST	25	25	EA
			BATCH 7363766671 Exp Date:		25	
00120		28	MS35207-263=28 SCREW: PAN HD,MACHINE,ST	100	100	EA
			BATCH 7364146696 Exp Date:		100	
00130		28	MS35842-11=28 CLAMP: HOSE,ST	10	10	EA
			BATCH 7364068983 Exp Date:		10	
00140		28	NAS1149D0463J=28 WASHER: FLT,AL	5,000	4,000	EA
00150		5N	PS890B2PT=5N KIT: SEALANT,FUEL TANK,PT	8	8	EA
			BATCH 7364161419 Exp Date: 10/01/2016		8	
00160		15	MS28775-011=15 ORING: NITRILE,70	200	200	EA

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For payment processing, please refer to Invoice.

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AMENDED.

CUSTOMER COPY

PACKING LIST



PAGE:3 of 4
DATE:19JAN16
TIME:20:13:04
EMP:00000000
ORD TYP: ZOR 132
CURRENCY:USD
TERMS:Net 30

DELIVERY NUMBER: 8002678875

ROUTE: US FedEx International Priority

CUSTOMER PO:PO31039
ORDER NUMBER:1001846114
ORDER DATE:19JAN16

B 10003951
I DART AEROSPACE LTD
L 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
T CANADA
O

S 10003951
H DART AEROSPACE LTD
I 1270 ABERDEEN STREET
P HAWKESBURY ON K6A 1K7
T CANADA
O

S 1000
H AVIALL CENTRAL WAREHOUSE
I DALLAS CDC
P 2750 REGENT BLVD
FROM DFW AIRPORT TX 75261-9048
USA

LINE	PO LINE	MFG	ITEM DESCRIPTION	ORDER QUANTITY	SHIP QUANTITY	QUANTITY BACK ORDER	UOM	LIST PRICE	CUSTOMER PRICE	EXTENDED CUSTOMER PRICE
SCREW: PAN HD,MACHINE,ST										
00130	0	28	BATCH 7364146696 MS35842-11 CLAMP: HOSE,ST	10	100 10	0	EA	3.55	0.61	6.10
00140	0	28	BATCH 7364068983 NAS1149D0463J WASHER: FLT,AL	5,000	10 4,000	1,000	EA	0.16	0.03	120.00
00150	0	5N	BATCH 7364125643 PS890B2PT KIT: SEALANT,FUEL TANK,PT	8	4,000 8	0	EA	144.72	64.70	517.60
00160	0	15	BATCH 7364161419 MS28775-011 ORING: NITRILE,70 Exp Date: 01OCT16	200	8 200	0	EA	0.87	0.15	30.00
00170	0	28	BATCH 7364131244 BATCH 7364142307 AN5-11A BOLT: HEX HD,ST Exp Date :01OCT29 Exp Date :01APR30	50	19 181 50	0	EA	1.54	0.27	13.50

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SP/6-01-21

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Signature

JR Hofmann, Director, Global Quality

19JAN16
Date

DISCOUNT TERMS APPLY ONLY TO SUB TOTAL. ALL
RETURNED MERCHANDISE SUBJECT TO HANDLING
FEE.
THIS IS TO CERTIFY THAT AVIALL HAS COMPLIED WITH
THE PROVISIONS OF THE FAIR LABOR ACT OF 1938
AMENDED.

CUSTOMER COPY



Commercial Invoice

8002678875

9303284999

Item	Part Number & Description	Country of Origin	Quantity	UOM	Unit Price USD	Extended Value USD
120	MS35207-263 - SCREW: PAN HD,MACHINE,ST Harmonized Tariff: 7318159000 Export Classification: 9A991.d Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039 Batch Number: 7364146696	US	100	EA	0.03	3.00
130	MS35842-11 - CLAMP: HOSE,ST Harmonized Tariff: 7326908595 Export Classification: 9A991.d Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039 Batch Number: 7364068983	US	10	EA	0.61	6.10
140	NAS1149D0463J - WASHER: FLT,AL Harmonized Tariff: 7616108000 Export Classification: 9A991.d Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039	US	4,000	EA	0.03	120.00
150	PS890B2PT - KIT: SEALANT,FUEL TANK,PT Harmonized Tariff: 3214100020 Export Classification: EAR99 Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039 Batch Number: 7364161419	US	8	EA	64.70	517.60
160	MS28775-011 - ORING: NITRILE,70 Harmonized Tariff: 4016930000 Export Classification: 9A991.d Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039	US	200	EA	0.15	30.00
170	AN5-11A - BOLT: HEX HD,ST Harmonized Tariff: 7318152000 Export Classification: EAR99 Authorization: NLRAT_JAN_2016 Sales Order: 1001846114 PO: PO31039 Batch Number: 7364094281	US	50	EA	0.27	13.50

Sp/b-01-21